

# Work Order ID 52508

September 29, 2009 10:11:55 AM



Page 1

Item ID: D3605-1

Accept



Setup Start



Revision ID: A

Stop



Item Name: Placard

Start Date: 9/29/09 Start Qty: 8.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: *CL*

Date: *09/29/29* Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Draw<br>Number | Draw<br>Rev. | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D3605    | Rev A        |

100 0.00



PURCHASING

Purchasing

Memo

0.00

Purchasing

Issue P/O: 10491 ☐ Manufacture as per Dwg D3605 using 3M 4mil classic plus clear vinyl with flexon flextwin white barrier film. ☐ Possible Supplier: Studio Lettrage ☐ Material release note is required

*CL 09/29/29* *(8)*

110 0.00



Receive & Inspect for Damage & Mat'l Certs

Packaging

Memo

0.00

Packaging

Ensure material release note is attached

*10/5/30* *(8)*

120 0.00



QC6- Inspect dimensions to drawing

QC

Memo

0.00

Quality Control

*27 802/02/30*

*(+8)*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Work Order ID 52508

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Page 2

Item ID: D3605-1

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Setup Start



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Item Name: Placard

Start Date: 9/29/09 Start Qty: 8.00



Cust Item ID:

Required Date: 9/30/09 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location:

0.00



Composites

Packaging

Memo

0.00

Packaging

RT 09-09-30 X8

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/30/05 HJ

D3605-1P

#52508 X8 - MF 09-10-01

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                        |                         |   |                        |
|------------------------|-------------------------|---|------------------------|
| DESIGN<br>13           | DRAWN BY<br>13          | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>[Signature] | APPROVED<br>[Signature] | DRAWING NO.<br>D3605                              | REV. A<br>SHEET 1 OF 1 |
| DATE<br>07.02.27       |                         | TITLE<br>PLACARD                                  | SCALE<br>1:1           |
| A                      | 07.02.27                | NEW ISSUE   |                        |

RELEASED  
07.04.03

1.00  
**CARGA DISTRIBUÍDA MÁXIMA**  
20.50

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 52508

**D3605-1 PLACARD**

MATERIAL: 1" HIGH RED LETTERS ADHESIVE BACK  
MANUFACTURED FROM 3M 7 MIL MASKING FILM #8522CP OR  
AVERY IPM #2031

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210 MAIN W.,  
HAWKESBURY, ONT. K6A 2H6

Tel.: 613 632-2001  
Fax: 613 632-9491  
www.studiolettrage.com

# INVOICE / FACTURE

VENDU À:  
SOLD TO:

LIVRÉ À:  
SHIPPED TO:

No.: 12823  
DATE: 09/30/2009  
PAGE 1 of 1

Re: Quote No. 7708

Dart Aerospace Ltd  
1270 Aberdeen  
Hawkesbury, Ontario K6A 1K7

Dart Aerospace Ltd  
Hawkesbury, Ontario

| ITEM<br>ARTICLE   | QTY<br>QYE | UNIT<br>UNITÉ | DESCRIPTION  | GST<br>TPS | PST<br>TVP | UNIT PRICE<br>PRIX UNITE | AMT<br>MON |
|---|------------|---------------|--|------------|------------|--------------------------|------------|
|   |            | 8<br>1        | D3605-1P<br>set up<br><br>E - GST @ 5%<br>G - GST @ 5%; PST @ 8%<br>GST<br><br>PST Exempt: #6122-5207<br><br><i>S</i><br><i>01/01/30</i> | G<br>E     |            | 6.00<br>50.00            | 48<br>50   |
| Studio de Lettrage GST: #869034678RP001<br><br>PO 10491<br><br>Sold By: |            |               |  |            |            | <b>TOTAL</b>             | 102        |

*Merci! Thank You!*



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO10491**

Purchase Order Date 9/29/09

PO Print Date 9/29/09

Page Number 1 of 1

**Order From :**

VC-STU001

**FXED**  
09/29/09

STUDIO DE LETTRAGE 2001  
210 MAIN WEST  
HAWKESBURY, ON K6A 2H6  
CA

|                           |              |                        |                |
|---------------------------|--------------|------------------------|----------------|
| <b>Contact Name</b>       |              | <b>Buyer</b>           | Chantal Lavoie |
| <b>Vendor Phone</b>       | 613 632 5449 | <b>Requisition Nbr</b> |                |
| <b>Vendor Fax</b>         | 613 632 9491 | <b>Tax Resale Nbr</b>  | 10127-2607     |
| <b>Vendor Account Nbr</b> |              | <b>Terms</b>           | Net 30         |
|                           |              | <b>Currency</b>        | CAD            |
|                           |              | <b>FOB</b>             |                |

**Ship To :** DART AEROSPACE LTD 1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

| Line Nbr | Reference<br>Revision ID<br>Vendor Part Number | Description/<br>Mfg ID | Req Date/<br>Taxable | Req Qty/<br>Unit of Measure | Ship Method | Unit Price | Extended<br>Price |
|----------|--|------------------------|----------------------|-----------------------------|-------------|------------|-------------------|
| 1        | D3605-1P                                       | PLACARD                | 9/30/09<br>Yes       | 8.00<br>Each                | Yours ppd   | \$5.0000   | \$40.00           |

**Special Inst:** AS PER DWG D3605 REV. A  
B52508

**PO Total:** \$40.00

CERTIFICATE OF CONFORMITY  
REQ'D UPON DELIVERY

*received A.S.A.P please.  
thanks  
Chantal*

*u*

*CL*

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

**Change Nbr:** 1

**Change Date:** 9/29/09



## PRODUCT DATA BULLETIN

Product Data Bulletin: A5-O

**Avery Graphics™ A5 Opaque**  
5-year **INTERMEDIATE** calendered vinyl film  
Dated: 10/3/02

### Description:

Avery Graphics™ A5 Opaque intermediate films are flexible, high-gloss calendered vinyls designed for use on computer sign cutting equipment. This construction provides excellent cutting, weeding and transferring characteristics for signage applications.

Application information can be found in the Avery Graphics Application Guide.

For surface preparation, converting and printing, and application and removal instructions, please refer to the Avery Graphics Instructional Bulletin.

### Construction:

- Face Film: 3.2 mils opaque medium gloss intermediate calendered vinyl film
- Adhesive: 1.0 mil clear acrylic permanent solvent pressure-sensitive adhesive
- Liner: 78# bleached white kraft

### Physical Properties:

The following information on physical and chemical characteristics is based upon tests believed to be reliable. The values are intended only as a source of information. They are given without guarantee and do not constitute a warranty. The purchaser should independently determine, prior to use, the suitability of this material for his/her specific purpose. (Data represents averages and is not intended for use as a specification).

- Outdoor durability: 5 years when properly processed and applied (vertical exposure, unprinted film)\*\*
- Application surface contours: Flat and simple curves
- Minimum surface and air application temperature: +50° F (10° C)
- Service Temperature Range: -40° F to +180° F (-40° C to 82° C) (Reasonable range of temperatures which would be expected under normal environmental time and temperature conditions)
- Typical Chemical Resistance: Resistant to most mild acids, alkalis and salt solutions. See instructional bulletin for recommendations on cleaning.
- Shelf Life: One year when stored at the following temperatures and humidity conditions: 68°-77° F (20° - 25° C) and 50±5% R. H.
- Typical Adhesion Values: **180° Peels**

| Substrate       | 24 hrs     | 1 week     |
|-----------------|------------|------------|
| Stainless Steel | 4.4 lbs/in | 5.1 lbs/in |
| Glass           | 4.7 lbs/in | 5.3 lbs/in |

NOTE: Tested per ASTM D 1000. Always pre-test your specific substrate prior to actual application.

- Reflectivity: NA
- Typical Gloss\*: 70 at 60°



- Tensile at Yield: 9.0 lbs/in to 15.0 lbs/in width
- Elongation: 100% minimum
- Dimensional Stability: Less than 0.03 in. (0.762mm). Shrinkage is determined by measuring shrinkage of unprinted film applied to to 36 in.<sup>2</sup> (91 cm<sup>2</sup>) aluminum test panel after 72 hrs. aging at 73° F (23° C) 50±5% R.H. followed by 48 hrs. at 150° F (65° C).

**Typical Converting Methods:**

**CUTTING**

Computer Sign Cutting: yes

Angle of Blade: 30° or 45°

Minimum letter Height: 0.5 inch

**PRINTING**

Thermal Transfer Printing: yes

Ink Jet Printing: no

E-Stat printing: no

Screen Printing: no

**Exceptions:**

Durability Exceptions: Colors with reduced durabilities are as follows: A5077-O Silver and A5247-O Gold are 3-year durable and A5003-O Clear is 4-year durable.

Gloss Exceptions: A5077-O Silver, A5247-O Gold and A5508-O Vibrant Blue have a typical gloss of 50 at 60°.

Pigmented Adhesive Exceptions: none

\*\* Some color fade may occur in severe environmental areas such as, Florida, Arizona, Nevada, New Mexico, Utah, Southwest Texas and Southern California. Durability statement does not apply outside of the contiguous 48 states as testing has not been done in those regions.

WARRANTY: All statements, technical information and recommendations about Avery Dennison products are based upon tests believed to be reliable but do not constitute a guarantee or warranty. All Avery Dennison products are sold with the understanding that Purchaser has independently determined the suitability of such products for its purposes. Avery Dennison products are warranted to be free from defects in material and workmanship for either one year (or the period stated on the specific product information literature in effect at time of delivery, if longer) from date of shipment if said product is properly stored and applied. It is expressly agreed and understood that Avery Dennison's sole obligation and Purchaser's exclusive remedy under this warranty, under any other warranty, express or implied, or otherwise, shall be limited to repair or replacement of defective product without charge at Avery Dennison's plant or at the location of product (at Avery Dennison's election), or in the event replacement or repairs is not commercially practical, to Avery Dennison's issuing Purchaser a credit reasonable in light of the defect in the product.

Avery Dennison's liability for defective products shall not exceed the purchase price paid therefore by Purchaser and in no event shall Avery Dennison be responsible for any incidental or consequential damages whether foreseeable or not, caused by defects in such product whether such damage occurs or is discovered before or after replacement or credit, and whether or not such damage is caused by Avery Dennison's negligence

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